

Date: Tuesday, 08/04/2008 1:08:21 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TUBE ASSEMBLY 8"
Job Number :	38499		
Estimate Number :	11195		
P.O. Number :		Part Number :	D3298011
This Issue :	08/04/2008	Drawing Number :	D3298 REV A2
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	A2
Previous Run :		Material :	
Written By :		Due Date :	15/04/2008
Checked & Approved By :		Qty:	6
Comment :	Est A 04-09-08 New issue KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W035	6061-T6 Tube .375 x.035W
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Comment: Qty.: 0.6999 f(s)/Unit Total : 4.1996 f(s)

Cut tube to length as per Dwg D3298

Material: 6061-T6 (WW-T-700/6) tubing Ø0.375" x 0.035" wall (M6061T6T0.375W.035)

Identify as D3298-011

Batch: M104921

2.0	MS208196D	Sleeve
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Sleeve

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	MS20819-6D	Sleeve	<u>M107534</u>
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3.0	AN8186D	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Coupling Nut

Pick:

Qty	Part Number	Description	Batch
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2	AN818-6D	Nut	<u>M103154</u>
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/04/2008 1:08:22 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY 8"

Job Number: 38499

Part Number: D3298011

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend tube as per template D3298-011T1 & Dwg D3298

Flare end as per Dwg D3298.

Ensure that sleeves and coupling are installed first

ml 08/04/09 **X6**

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sc 08/04/09 **(6)**

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: *LC 8/4/10* **(6)**

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/14 **MF**

Job Completion



mf 08-04-10

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3298	REV. A SHEET 1 OF 7
DATE 04.07.06		TITLE TUBE ASSEMBLIES	SCALE NTS
A	04.07.06	NEW ISSUE	
A1	<i>[Signature]</i> 04.11.30	CORRECT VIEW D3298-003; 16.50 WAS 15.75	
A2	<i>[Signature]</i> 05.05.06	FOR D3298-001/-003 16.00 WAS 16.50	

RELEASED
04.07.09 *[Signature]*

P/N	TEMPLATE	CUT LENGTH OF TUBE	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL
D3298-001	D3298-001T1	25.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-003	D3298-003T1	27.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-005	D3298-005T1	23.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-007	D3298-007T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-009	D3298-009T1	6.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-011	D3298-011T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-013	D3298-013T1	10.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-015	D3298-015T1	14.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)

Notes:

- (1) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES
- (2) TUBES TO BE FLARED 37° TO MATE WITH FITTINGS MADE TO MS33514.
- (3) ENSURE SEAMLESS TUBING IS USED.
- (4) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- (6) ALL DIMENSIONS ARE IN INCHES
- (7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

[Handwritten signature]
38499

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

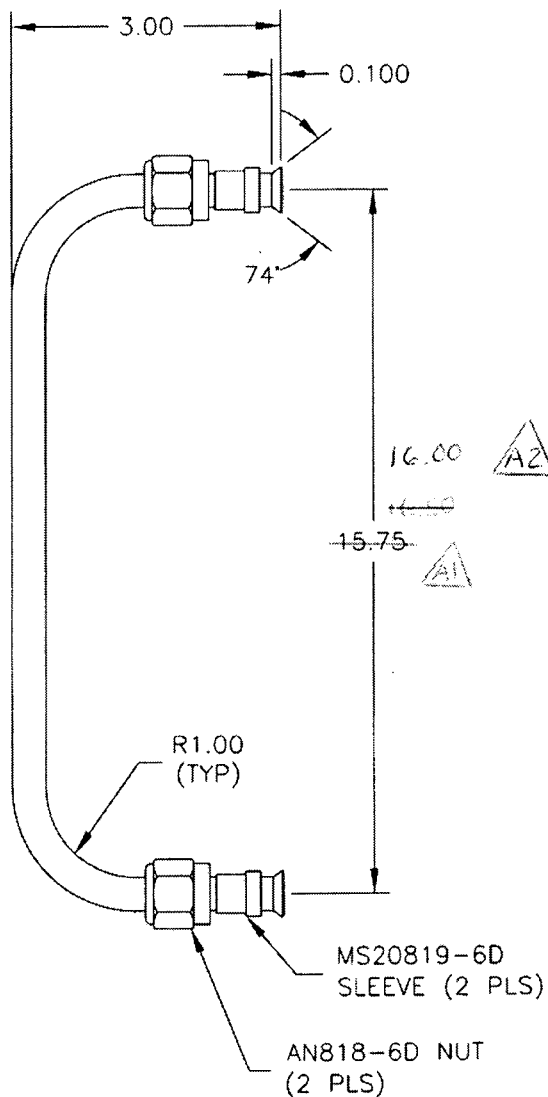
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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04.07.06 #



D3298-001

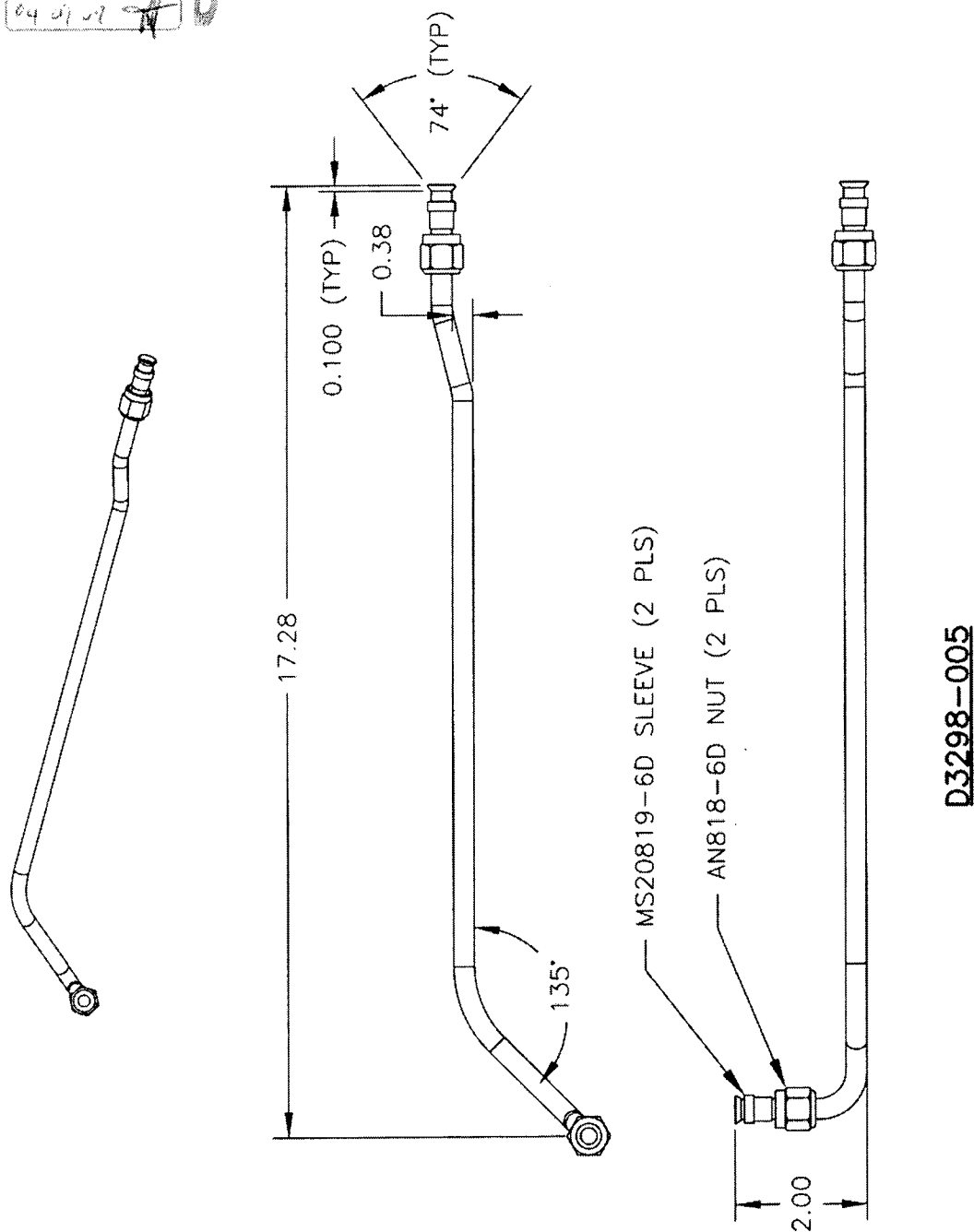
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DATE 04.07.06		TITLE TUBE ASSEMBLIES	SCALE NTS

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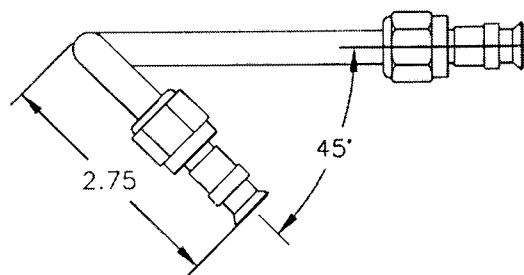
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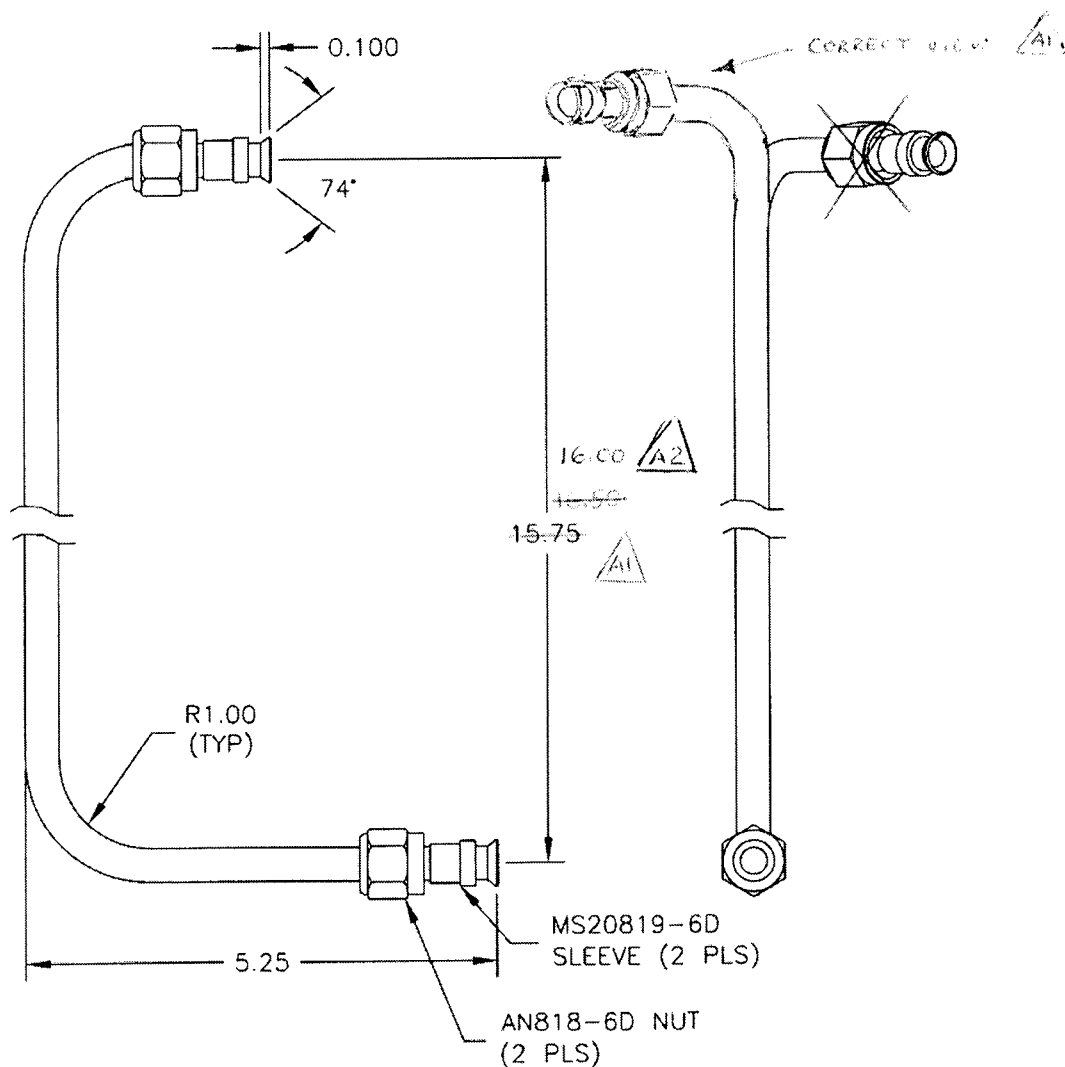


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D3298-003



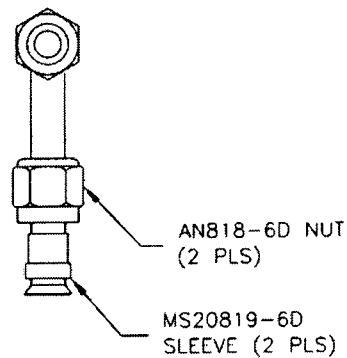
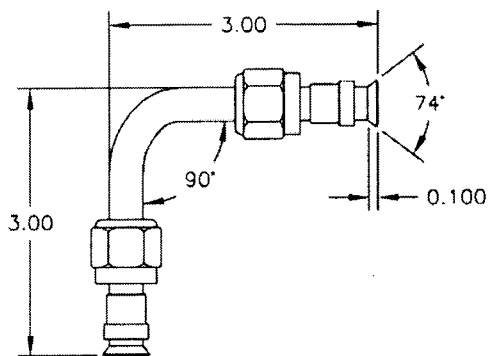
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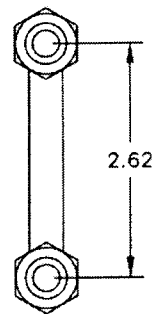
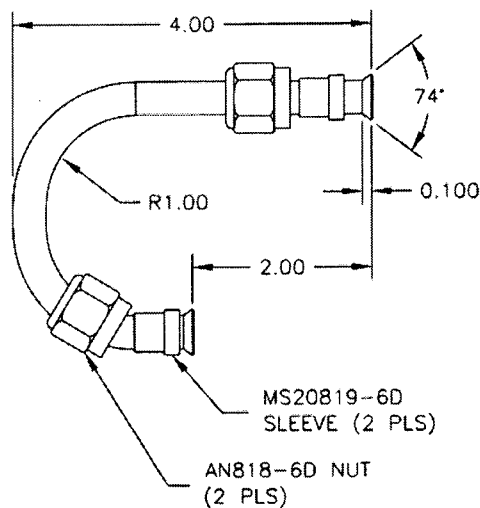


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D3298-007



D3298-013

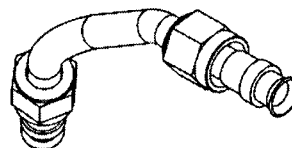
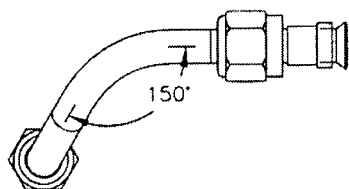
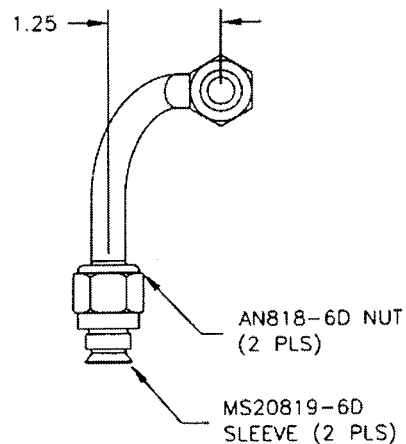
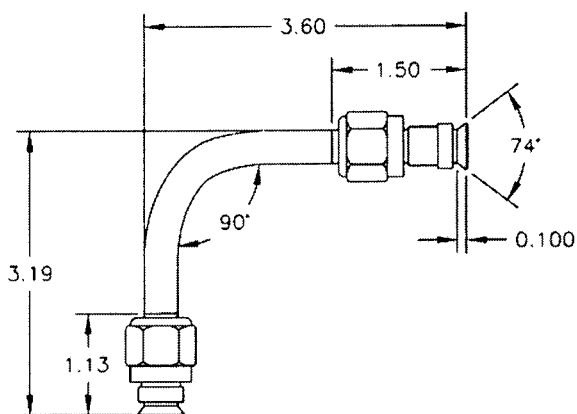
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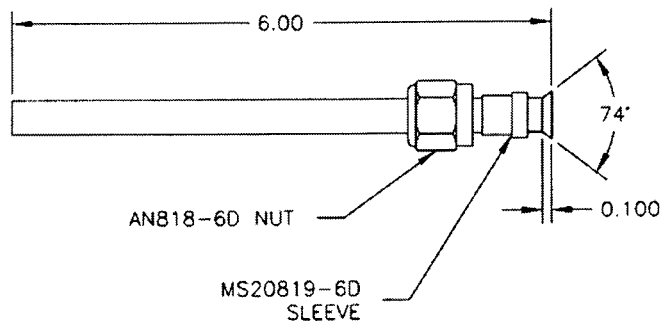


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D3298-011



D3298-009

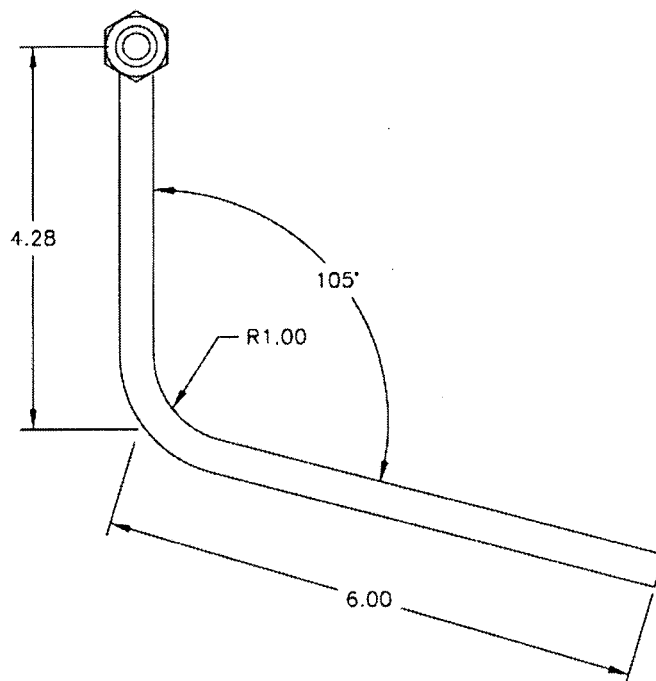
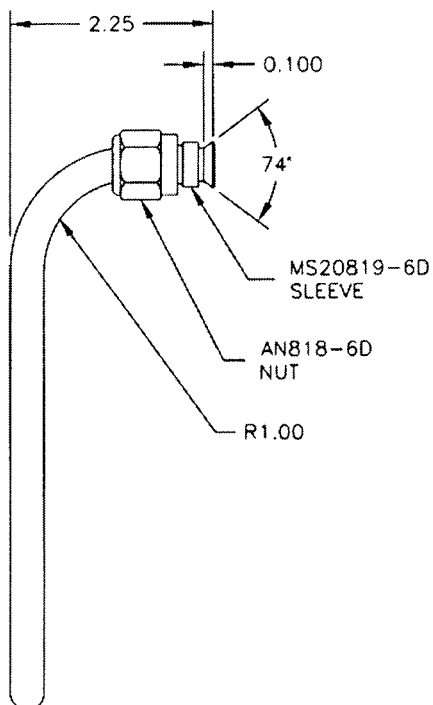
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D3298-015

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